

5120

23524

DART AEROSPACE LTD	Work Order:	23524
Description: Pedal Assembly	Part Number:	D3204-041
Dwg: D3204 Rev. A	Qty:	410
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travelers for: D3204-041 Pedal Assembly D3204-1 Tube D3204-7 Bushing Dwg not required	KJ	05.07.06	410
2	MV	Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x02.000) Identify for D3204-3	SD	05.07.07	10
3	MV	Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x01.250) Identify for D3204-5	SD	05.07.07	10
4	MV	Cut blank: 1.00" x 0.500" x 1.150" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x01.000) Identify for D3204-11	SD	05.07.07	10
5	MV	Cut blank: 2.000" x 0.375" x 3.100" long Bar Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x02.000) Identify for D3204-9	SD	05.07.07	10
6	MV	Machine D3204-3 as per Folio FA344 and Dwg D3204 Identify as D3204-3	SD	05.07.07	10
7	QC2	Inspect parts as they come off the CNC machine	SD	05.07.07	10
8	MV	Deburr	SD	05.07.07	10
9	QC8	Second check	EC	05.07.08	10
10	MV	Machine D3204-5 as per Folio FA344 and Dwg D3204 Identify as D3204-5	SD	05.07.08	10
11	QC2	Inspect parts as they come off the CNC machine	SD	05.07.08	10
12	MV	Deburr	SD	05.07.08	10
13	QC8	Second check	EC	05.07.08	10
14	MV	Machine D3204-11 as per Folio FA357 and Dwg D3204 Identify as D3204-11	SD	05.07.08	10
15	QC2	Inspect parts as they come off the CNC machine	SD	05.07.08	10
16	MV	Deburr	SD	05.07.08	10
17	QC8	Second check	EC	05.07.08	10
18	MV	Machine D3204-9 as per Folio FA357 and Dwg D3204 Identify as D3204-9	BG	05.07.09	10
19	QC2	Inspect parts as they come off the CNC machine	BG	05.07.09	10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

23524

DART AEROSPACE LTD		Work Order:	23490
Description: Pedal Assembly		Part Number:	D3204-041
Dwg: D3204 Rev. A		Qty:	4
Page 2 of 2			

Step	Location	Procedure	By	Date	Qty								
20	MV	Deburr	BG	05.07.09	10								
21	QC8	Second check	EN	05/07/09	10								
22	WA	Cut (2) D3204-13 per Assembly Cut blanks as per Dwg D3204 Material: 6061-T6 (QQ-A-250/11) 0.125" thick (M6061T6S.125) Identify as D3204-13 Batch: <u>M11946</u>	CPL	05.07.15	10								
23	WA	Grind hypotenuse side	CPL	05.07.15	10								
24A	WA	Weld assembly as per Dwg D3204 using Jig D3204-041T1 Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th></tr></thead><tbody><tr><td>1</td><td>D3204-1</td><td>Tube</td></tr></tbody></table> Identify as D3204-041	Qty	Part Number	Description	1	D3204-1	Tube	CPL	05.07.15	10		
Qty	Part Number	Description											
1	D3204-1	Tube											
25	QC5/9	Inspect weld	2	05.07.18	10								
26	FP	Chemical Conversion Coat as per QSI 005 4.1	PMC	05-7-18	10								
27	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 D3204-041 Note: Cover holes for bushing	FC	050729	10								
28	QC3	Inspect Powder Coat	AB	050729	10								
29	GA	Install D3204-7 bushing as shown in Dwg D3204 Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D3204-7</td><td>Bushing</td><td>B23524</td></tr></tbody></table>	Qty	Part Number	Description	Batch	2	D3204-7	Bushing	B23524	ml	05/08/03	10
Qty	Part Number	Description	Batch										
2	D3204-7	Bushing	B23524										
30	QC5	Inspect work to Step 29	2	05-08-05	10								
31	ST	Identify and Stock D3204-041 Qty: <u>10</u> D3204-1 Qty: <u>0</u> D3204-7 Qty: <u>4</u> Note: D3204-1/-7 are stocked in welding cell	CPL	05/08/10	10								
32	AC	Parts to Stock and Prorate Cost to parts per Step 31 Cost / part <u>84.77</u>	S45	05-08-26	10								
33	DC	Close W/Order and Ensure Travelers attached Inspect Level 21 <u>84.77</u> Travelers: D3204-041 D3204-1 D3204-7	CPL	05/08/11	10								

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Added Travelers	KJ/RF	

24B WA DRILL ~~1/4~~ DIA HOLE ~~IN~~ THE CENTER OF
 Ø 0.760 C'BORE ON D3204-5 ARM PRIOR OF
 WELD. USE J.B. WELD COMPOUND TO PLUG
 THE HOLE AFTER ASSEMBLY. GRIND FLUSH
 J.B WELD AFTER IT IS CURD.

CPL 05.07.15
RELEASED
 RF 04.06.21

RF 05.07.15

PTO

PTO 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
050706	24	permanent change	L			L	J 05-07-18

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 07, 2005
11:56 am

Work Order No : 0023524
Project Name : D3204-041
Project For : WK526
Work Order Type : Main
Main WO Number :
House Part Number : D3204-041
Description : Pedal Assembly
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 06-07-05
Est Finish Date : 06-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

CONTROLLED COPY

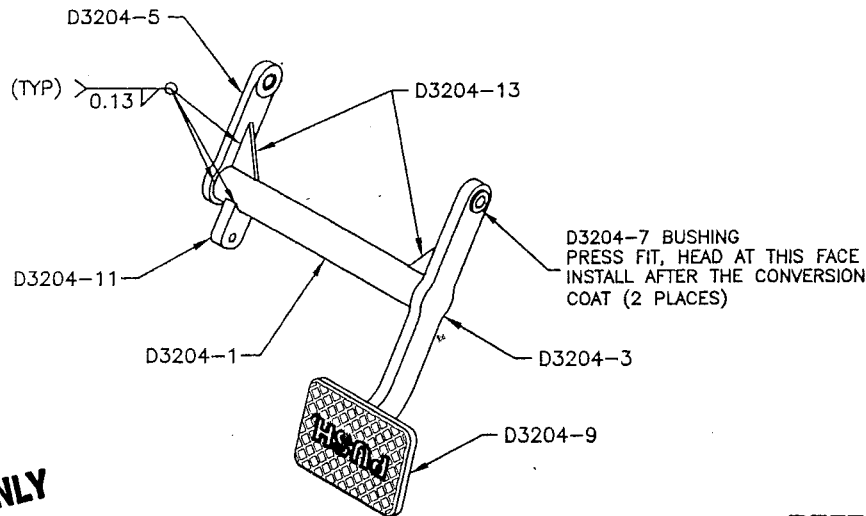
DART



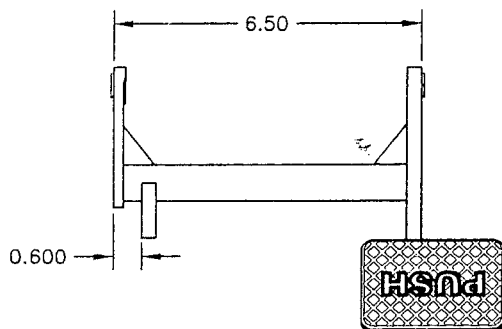
CONTROLLED COPY

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	

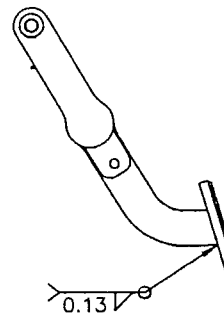
RELEASED
04.04.30



REFERENCE ONLY



REFERENCE ONLY



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

5/26

DART AEROSPACE LTD	Work Order:	23524
Description: Tube	Part Number:	D3204-1
Dwg: D3204 Rev. A page 2	Qty:	24
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	JG	05.06.08	24
2	MC	Turn D3204-1 tube as per Folio FA356 and Dwg D3204 Material: 6061-T6/-T62 (QQ-A-200/8) Ø0.750" x 0.125" wall (M6061T6T0.750W.125) M13848 Identify for D3204-1 Batch: M15972	JG	05/07/07	24
3	QC2	Inspect parts as they come off the CNC machine Identify as D3204-1	JG	05/07/08	24
4	MC	Deburr	JG	05/07/08	24
5	QC8	Second check	BE	05.07.08	24
6	MC	Go to D3204-041 for welding	✓ CPL	05.07.15	24

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Change Step 6; remove Steps 7 & 8	KJ/RF RF	RF

RELEASED

RF 04-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

226

DART AEROSPACE LTD	Work Order:	23524
Description: Bushing	Part Number:	D3204-7
Dwg: D3204 Rev. A page 2	Qty:	24
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	KJ	05.06.08	24
2	MC	Turn D3204-7 bushing as per Folio FA355 and Dwg D3204 Material: AISI 303 SS Ø0.50" (M303R0.500) Identify for D3204-7 Batch: M16719	YD BG	05/08/02	24
3	QC2	Inspect parts as they come off the CNC machine Identify as D3204-7	YD BG	05/08/02	24
4	MC	Deburr	YD BG	05/08/03	24
5	QC8	Second check	YD BG	05/08/03	24
6	MC	Go to D3204-041 for assembly	YD BG	10/08/03	24

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Change Step 6; remove Steps 7 & 8	KJ/RF RF	RF

RELEASED

RF 04.06.21

Change
RF
7/27/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

